

3/25

DART AEROSPACE LTD	Work Order:	23537
Description: Saddle billet	Part Number:	D6101-013
Drawing: D6101 Rev. A	Qty:	8

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Open W/O	KL	05.06.08	8
2	PURCHASING	Issue P/O: 7008245 a) Description: Alluminum billet b) 10.100" x 8.250" x 2.50" thick (+0.030 / -0.000) c) Tolerance on all dimensions are +0.030"/-0.000" d) Grain direction along 10.100" length e) Material: 7075-T7351 (QQ-A-250/12) Material certification required	U	050603	8
3	RECEIVING	Receive & Inspect for transit damage Ensure certification are attached	DL	05/06/22	8
4	QC	Inspect level 6 Check certification to Dwg D6101 for compliance	En	05/07/06	8
5	STORES	Identify & stock	En	05/07/06	8
6	EXPEDITING	Close W/O 152.78 Cost / part 161.07	Inspect Level 21	05/07/14	8

Rev	Date	Change	Revised By	Approved
A	01.05.04	New Issue	EC	EC

RELEASED

01.05.16

RF
23.06.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

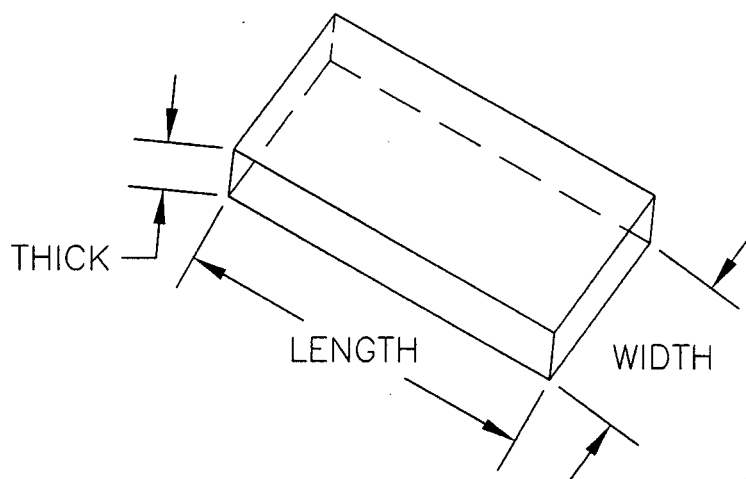
QA: N/C Closed: _____ Date: _____



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>JS</i>	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 *CP*



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.100 Length

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 23537

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 07, 2005
11:54 am

Work Order No : 0023537
Project Name : D6101-013
Project For : WK525
Work Order Type : Main
Main WO Number :
House Part Number : D6101-013
Description : Saddle billet
Manufactured : Yes
Amount Req'd : 8
Amount Done : 0
Start Date : 06-07-05
Est Finish Date : 06-24-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Mark J. Vrablec

Mark J. Vrablec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

406512
Ship Date

2005-05-03

P.O. No./Govt Contract No.

W23677

120034
B.L. No.

74936

Invoice No.

09797

Customer

C&B-FRESNO

Alcoa No. Item

DS-84015-1

Page

CQR: 0147255.4 -Specification Limits (cont.)

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Other	Other
Alloy 7075	Max	.40	.50	2.0	.30	2.9	.28	6.1	.20	.05
	Min			1.2		2.1	.18	5.1		

REMAIN

Lot: 352281 -Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No.	UTS	TYS	EL4D
T7351	Long Transv.	3	Max	72.5	62
			Min	72.3	61.9
T7351	Elect Cond	%IACS	40.3	40.4	40.3

Cast Number	Chemical	SI	FE	CU	MN	MG	CR	ZN	TI
H9745045	Actuals	.06	.28	1.6	.02	2.6	.19	5.7	.02

Lot: 352282 -Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No.	UTS	TYS	EL4D
T7351	Long Transv.	3	Max	73.3	63
			Min	73.1	62.7
T7351	Elect Cond	%IACS	40.1	40.2	40.3

Cast Number	Chemical	SI	FE	CU	MN	MG	CR	ZN	TI
H9745045	Actuals	.06	.28	1.6	.02	2.6	.19	5.7	.02

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Mark J. Vrabec

Mark J. Vrabec
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

406512
Ship Date

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Alcoa No. Item

DS-84015-1

Page

Ship To: COPPER & BRASS SALES INC.
FRESNO BRANCH
5450 E.HOME
FRESNO, CA 93727

Item Description

2.500 IN TK X 48.5 IN W X 144.5 IN LN (N) A/T 7075-
T7351 RECTANGLE MILL FINISH, USI 3MM DEAD ZONE REQ'D BOTH SIDES,
SAWED ({ P/N 091557-9 }). PER AMS-QQ-A-250/12 & EXCEPT MARKING AMS-
STD-2154 & EXCEPT MARKING MMS159 REV N &
EXCEPT MARKING ASTMB209 REV 04 & EXCEPT
MARKING BSS7055 REV A & EXCEPT MARKING
AMS4078 REV F ((MARKED)) INTERLEAVED
MAX GROSS SKID WGT: 5000 LB QUAN TOL +/-
40 % USI CL A 3 MM CQR 0147255 REV 04 CUST REQ 05-04-
17 *** W/E 05-04-23 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl
1	283115	352281	1785	1	PC	
2	283115	352282	1786	1	PC	
3	283195	352281	1780	1	PC	
4	283195	352282	1779	1	PC	
			7130	4		

Notes for CQR: 0147255.4

THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMMERSION - TYPE I.
PRODUCT PRODUCED TO THE REQUIREMENTS OF MIL-STD-2154 ALSO MEET THE REQUIREMENTS OF AMS-STD-2154. PRODUCT PRODUCED TO THE
REQUIREMENTS OF AMS-STD-2154 ALSO MEET THE REQUIRE- MENTS OF MIL-STD-2154.
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/12 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/12F. PRODUCT
PRODUCED AND MARKED TO THE REQUIRE- MENTS OF QQ-A-250/12F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/12.

CQR: 0147255.4 -Specification Limits

Temp	Dir	Max	Min	UTS KSI	TYS KSI	EL4D PCT
T7351	Long Transv.	63.9	66.0		52.0	6
T7351	Elec. Cond. (EC)	% MIN	38.0		PCT	